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RBE703A94-1130-01
Job Sheet 183083



Part No: RBE703A94-1130-01

Job Qty: 1 ea *2 MLC*

Part Name: Main Rotor Blade Trim Tab Tools Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/12/18

Job Tracking No:

Due Date: 9/13/18 *A-17*

Created By: Logan David

Type: SOLD

Description:

Note: DWG RBE703A94-1130-01 Rev K IPP Rev A 17.10.27 New issue DP Verify DD/IPP Rev B 17.11.30 DWG Rev K DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		9/13/18	0.00	0.00	Start Up Small Fab-2		<i>MLC</i>
110	Small Fab	1 pcs		9/13/18	0.00	1.00	Small Fab-3		<i>MLC</i>
120	QC	1 pcs		9/13/18	0.00	0.00	QC5		<i>SB</i>
130	Packaging	1 pcs		9/13/18	0.00	0.00	Packaging3-1		<i>SB</i>
140	QC21-FG	1 Ea		9/13/18	0.00	0.00	QC21		<i>MLC 18-09-25</i>

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
Descriptions: APP-1450-E 3-Deburr holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue foam to case and pack case as per DWG.

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
97524A032	Sealing Blind Rivet	4 Ea (4 ea)	90-Start up Operation	
APP-1450-E	Case	1 Ea (1 ea)	90-Start up Operation	
RB41011	Dart Tooling Placard, Aluminum	1 Ea (1 ea)	90-Start up Operation	
RBE703A94-1130-01-01	Immobilizing Clip Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5113031</i>
RBE703A94-1130-01-23	Deflection Clip Assembly	1 Ea (1 ea)	90-Start up Operation	<i>5108681</i>
RBE703A94-1130-01-47	Bottom Foam use in case APP-1450-E	1 pcs (1 ea)	90-Start up Operation	
RBE703A94-1130-01-49	Top Foam use in case APP-1450-E	1 pcs (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	97524A032	4	539	0
	APP-1450-E	1	17	0
	RB41011	1	791	0
	RBE703A94-1130-01-01	1	1	0
	RBE703A94-1130-01-23	1	5	0
	RBE703A94-1130-01-47	1	17	0
	RBE703A94-1130-01-49	1	17	0

Part Specifications

Specifications could not be found.

Date: 09/24/18

Instructions:
Exp Date:
Inspector:
Revision: K

Serial No/Batch: S113121
Job No: 183083

Part: FBE703A94-1130-01



Container No: S113121

DART
AEROSPACE

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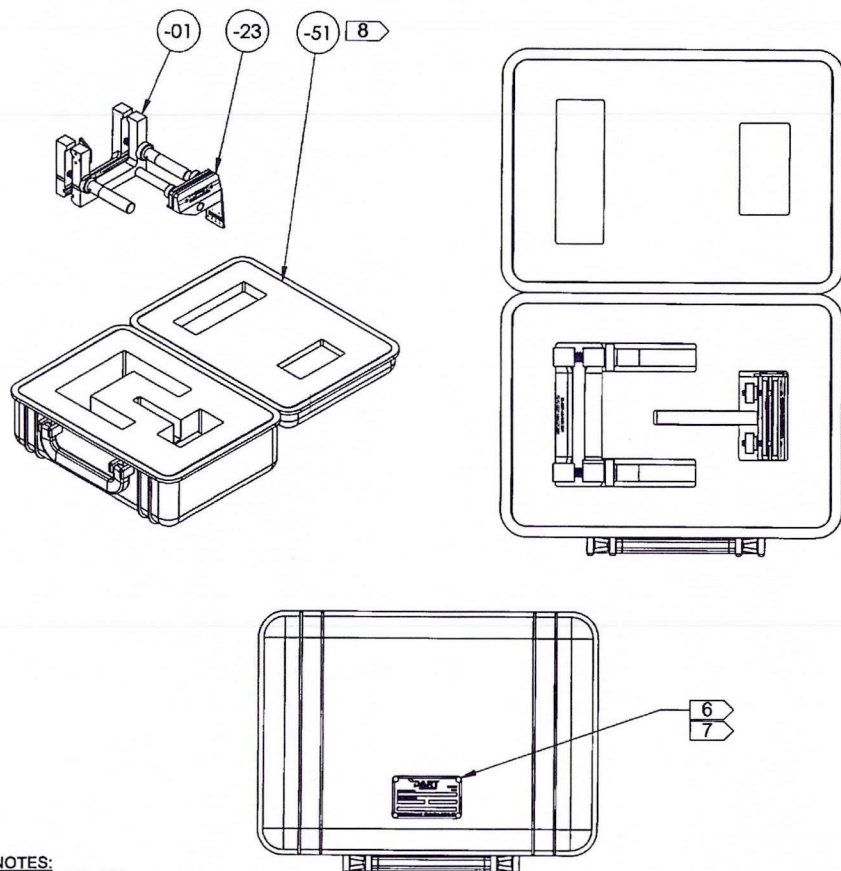
ITEM #	QTY	PART #	TITLE	PG
-01	1	RBE703A94-1130-01-01	IMMOBILIZING CLIP ASSY	2
-23	1	RBE703A94-1130-01-23	DEFLECTION CLIP ASSY	9
-51	1	RBE703A94-1130-01-51	PACKAGING ASSY	15
52	1	RB41011	DART PLACARD	-
53	4	McMaster#97524A032	RIVET 1/8" x 0.425" LG.	-

D

C

B

A

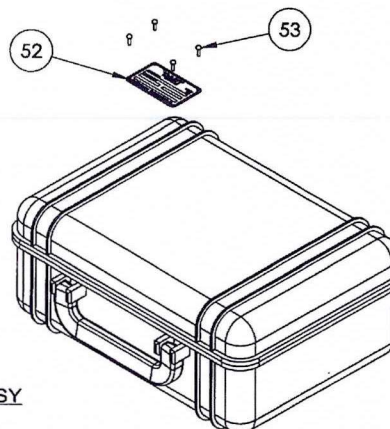


NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) HEAT TREAT: N/A
- 4) SPEC: N/A
- 5) BREAK ALL SHARP EDGES: N/A
- 6) IDENTIFICATION: ENGRAVE P/N & S/N WHERE INDICATED ON DART PLACARD (ITEM 52) BEFORE INSTALLATION ON THE PELICAN CASE (ITEM 45)
- 7) CENTER DART PLACARD (ITEM 52) IN AVAILABLE AREA OF THE PELICAN CASE'S LID (ITEM 45)
- 8) HOT GLUE TOP AND BOTTOM FOAM (ITEM -47 & -49) INTO THE PELICAN CASE (ITEM 45) AFTER DART PLACARD'S (ITEM 52) INSTALLATION
- 9) OEM P/N: E-703494-1130-01

RBE703A94-1130-01 MAIN ROTOR BLADE TRIM TAB TOOLS ASSY

REV.	DESCRIPTION	DATE	BY	APPROVED
1	MOVED P/Ns -27, -28 FROM PAGE 3 TO 4. CHD ENGRAVE NOTE P/N -03. CHD HOLE DIA. P/N -25 & ADDED P.F. CHD DOWEL DIM TO METRIC ONLY. CHD P/N -27 ROLL PIN HOLE DIA. TO 4mm ONLY ADDED P.F., CHD RADIUS DIM P/N -27, CHD DOWEL DIM TO 4mm ONLY ADDED DEPTH .354. CHD RADIUS DIM -29.	5/1/2009	RJC	RW
1A	-49 ADDED LID FOAM.	4/13/2011	RJC	RW
2	CHD -03 & -49 NOTE 1 PER R.W. CHD -05 DOWEL PIN HOLE FROM Ø 118in. [3mm] PER G.E. -09 CHD C-DRILL FROM Ø4mm TO Ø 170 PER G.E. CHD -11 Ø 118 HOLE FROM P.F. TO S.F. PER G.E. CHD -21 FROM Ø3mm x 20mm PER R.W. ADDED -28 DIMENSION 1.250in. [32mm] TO ENSURE -25 WILL S.F. INTO -27 PER G.E. CORRECTED -27 & -29 CHAMFER DIMENSION FROM 1.97in. TO .197 PER G.E. ADDED -51 TO BOM. CHD -41 FROM DOWEL PIN.	9/16/2011	RJC	-
2A	ADDED -09 MISSING Ø3mm HOLE P.F. -19 DIMENSION. ADDED -27 MISSING R.062 DIMENSION PER G.E.	5/21/2012	RJC	GE
2B	CHD -03 & -09 FINISH FROM CLEAR ANODIZE TO RED ANODIZE, REMOVED POWDER COATING NOTES. CHD -07 WAS #91310A555 STEEL TO #91287A165 S.S. CHD -47 WAS ROLL PIN TO DOWEL PIN	4/17/2013	CFS	RW
3	-03, -09, -27 CHD ENGRAVE NOTE WAS RBEA94-1130-01 IS RBE703A94-1130-01. -45 CORRECTED VIEWS. CHD DIM WAS Ø.315 125 IS Ø.315 125 S.F. CHD DIM WAS Ø.129 THRU IS Ø.129/125. -07 ADDED DIM S.F. -25. CHD DIM WAS Ø.125 FOR -21 IS Ø.129/125 THRU. -09 CHD DIM WAS Ø.118 P.F. -19 IS Ø.118/0076 (x2). -11 CHD DIM WAS Ø.118 S.F. -19 (x2) IS Ø.1209/1197 (x2). -25 CHD DIM WAS Ø4mm P.F. -41 IS Ø.1575/1572. CHD DIM WAS .625 S.F. -27 IS (.625) S.F. -27 -27 CHD DIM WAS Ø4mm THRU S.F. -41 IS Ø.1627/1592 S.F. -41. CHD DIM WAS Ø4mm. .354 (x2) IS Ø.1575/1572 .35 (x2). ADDED MISSING DIM. 236. -31 CHD DIM WAS Ø.157 S.F. -41 (x2). IS Ø.1627/1592. ADDED MISSING DIM (.394). -47 ADDED DIM (4X) R.37.	6/24/2013	BIM	RW
4	-25 CHD DIM WAS LIMITS Ø.1572 TO .1575 IS LIMITS Ø.1564 TO .1570. -27 CHD DIMS WAS Ø.1592 TO .1607 IS Ø.1575/1590. WAS Ø.1572 TO .1575 IS Ø.1567/1571. -31 CHD DIM WAS LIMITS Ø.1592 TO .1607 IS Ø.1578 TO .1585.	4/10/2014	DPD	GE
5	SEE ECR 16-0272	12/30/2016	RJC	SM
6	SEE ECR 17-0164	6/26/2017	RJC	JAG
K	SEE ECN 17 623: TEMPLATE UPDATE AS PER HAWKESBURY STANDARDS. -07 MATERIAL CHANGE FROM M8 SCREW TO M304R AND TOLERANCE .315/306 CHANGE TO .307 +.003/-003 AND THREAD CLASS ADDED. -05 TOLERANCE .315/316 CHANGE TO .309 +.003/-0. ASSY -51 ADDED. RIVETS AND EMPLACEMENT OF THE PLACARD ON THE PELICAN CASE ADDED	11/20/2017	VM	WM



DART AEROSPACE Hawkesbury, Ontario, Canada		TITLE	
		MAIN ROTOR BLADE TRIM TAB TOOLS ASSY	
DWG NO.		REV	
RBE703A94-1130-01		K	
DESIGN BY:	VM 9/11/2017	XXX ± .005 FRACTIONS & 1/8	1. DIMENSIONS ARE IN INCHES UNLESS OTHERWISE SPECIFIED 2. INTERPRET DIM AND TOL PER ASME Y14.5M-2009 3. DIMENSIONAL LIMITS APPLY AFTER PLATING
DRAWN BY:	VM 11/24/2017	XX ± .01 ANGLES & 1/8	
CHECKED BY:	WM 11/30/2017		
MFG. APPR:	DP 11/30/2017		
APPROVED:	WM 11/30/2017		
DATE:	11/24/2017		
SCALE:	NTS	WEIGHT:	N/A
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